

	<b>Mixing Plastisol</b>		<b>Revision:</b> Initial Release
	<b>Document Control Number: 93.00-4 (7.3)</b>		<b>Date: 2/28/03</b>
<b>WORK INST.</b>	<b>Responsible Organization:</b> Office of Production Support		
	<b>Approved By:</b> Douglas Bernia	<b>Signature:</b> <SIGNED>	

- 1.0 Purpose:** To ensure that all Plastisol for the PVC wipers is manufactured according to standard procedure.
- 2.0 Scope:** This procedure applies to all Roller Coverers at the Washington, DC and Fort Worth, TX facilities.
- 3.0 Responsibilities:** It is the responsibility of all personnel to perform in accordance with established procedures.
- 4.0 References:**
  - 93.00-4 (7.13) Wiper Roller Formulae
  - 93.00-4 (7.12) Wiper Manufacturing and Control Equipment
  - De La Rue Giori Plastirola-Super Instruction Manual (April, 1992)
- 5.0 Procedure:** Mixing Plastisol
  - 5.1** Employee verifies all raw materials to be used against the appropriate formula as described in 93.00-4 (7.13) Wiper Roller Formulae.
  - 5.2** Display shows "READY" on the weighing station.
  - 5.3** Place the vessel on scale to be used for the formulation (vat is then tare weight).
  - 5.4** Go through sequence to weigh all ingredients as presented in the formula the system will prompt for the different raw materials by displaying "MORE" enter 'Y' to continue or 'N' to exit. A batch printout will automatically be generated when exiting and/or completing the formulation. The printouts are maintained in the section office for one month and then discarded.
  - 5.5** Start the weighing of the liquid ingredients in sequence and then the powdered ones. When adding the powdered ingredients, it will be necessary to use a spatula and/or electrical hand-held mixer to work down the powder into the vessel before lowering the head on the Ross Planetary mixer.
  - 5.6** Place the vat of mixed Plastisol under the planetary mixer.
  - 5.7** The vessel surface and rim must be well cleaned of debris with a knife, then use clean cheesecloth with alcohol, lightly dampen and further clean and dry the rim of the vessel. **Note:** The seal on the mixer head must be undamaged and clean.
  - 5.8** Lower the head on the mixers into the vat.
  - 5.9** Clamp the head down to the vessel, set the timer for 60 minutes, start the mixer and run for 30 minutes without vacuum. **Note:** Document for

personal/immediate reference the time of start up after 30 minutes has elapsed, turn on the vacuum and run an additional 30 minutes under vacuum.

- 5.10** After the first mix cycle is completed, strain the mix through a stainless steel open bottom special rim, using a 1000 per cm<sup>2</sup> mesh screen into a clean vessel.
- 5.11** Clean the stirrers, ports and head of the mixer well.
- 5.12** Re-mix the strained Plastisol under vacuum for 60 minutes.
- 5.13** When mixing is completed, pour the Plastisol into the correctly colored clean lined pail as indicated in the formula, write the batch number and date on a manila label and tape the label to the pail. **Note:** Plastisol is to be used by first in/first out date, which is labeled on tags. Black top layer Plastisol must be used within 24 hours. Black base layer Plastisol can be used up to within 48 hours. White layer Plastisol can be used within 72 hours.

Rev. #	Purpose of Revision	Eff. Date